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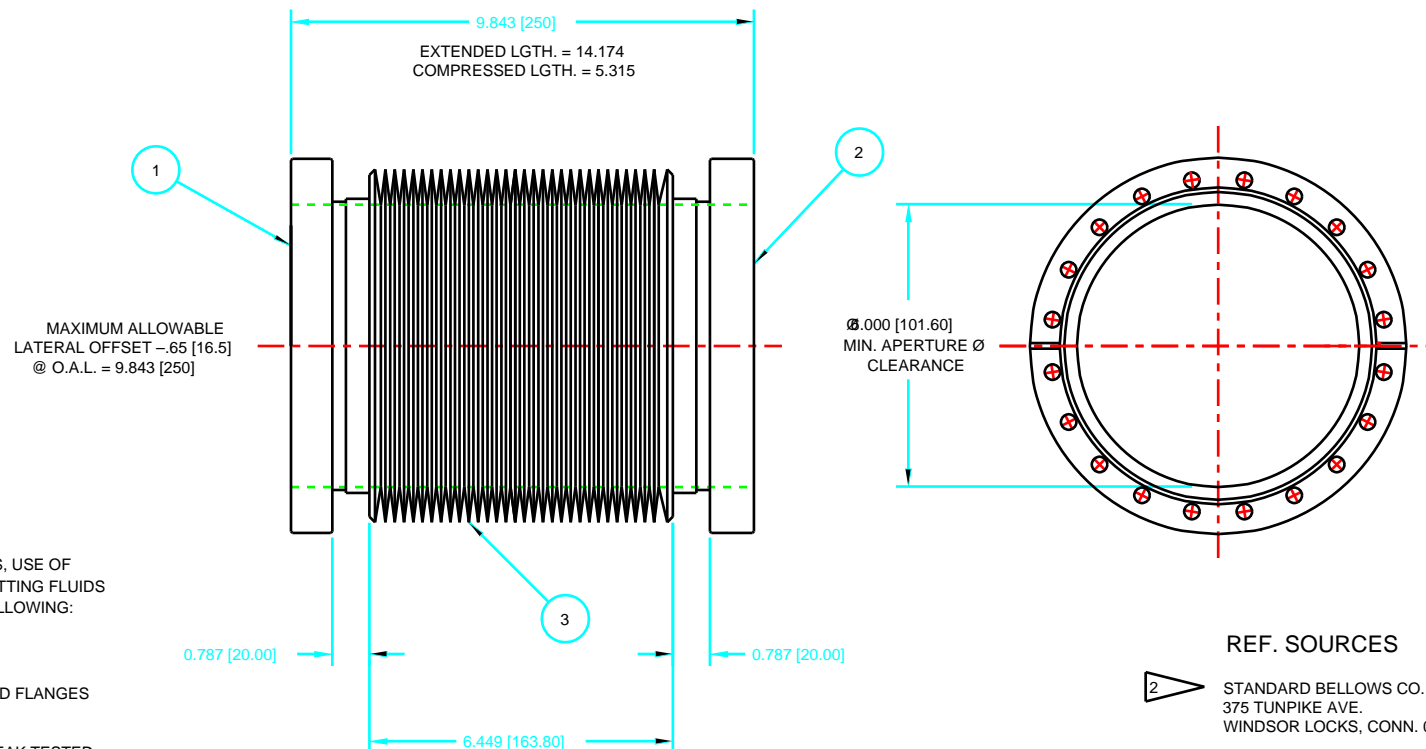
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NOTES:

1. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL

2. ALL WELDS JOINING BELLOWS AND FLANGES ARE TO BE INTERNAL

3. BELLOWS ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2 X 10⁻¹⁰ STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS
ALCATEL SAM-110TCL
Du PONT CEC 24-120B
VARIAN MS-9, MS-90 OR MS-18

CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TRESTING.

FINAL TEST WILL CONSIST OF SURROUNDING THE ASSEMBLY (BAGGING) WITH HELIUM. THE ASSEMBLY WILL BE REJECTED IF A 2% DEFLECTION ON THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.

4. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.

5. DIMENSIONS IN [] ARE MILLIMETERS

REF. SOURCES

- 2 STANDARD BELLOWS CO.
375 TUNPIKE AVE.
WINDSOR LOCKS, CONN. 06096
- 1 MDC VACUUM PRODUCTS CORP.
23842 CABOT BLVD.
HAYWARD, CA. 94545-1651



3		ST'D. BELLOWS CAT. #750 - 600 - 8 - EE	WITH EXTENDED ENDS	1
2	MDC'S CAT. #100031	8" CF. ROTATABLE FLANGE		1
1	MDC'S CAT. #110031	8" CF. NONROTATABLE FLANGE		1

ITEM	QTY/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				

UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES		THIS DRAWING IS THE PROPERTY OF	
TOLERANCES		ARGONNE NATIONAL LABORATORY	
DECIMALS	ANGLES	A14773	
.1	± .03 [7620]	± .25	
.25	± .01 [254]		
.5	± .005 [127]		
SURFACE ROUGHNESS 125		DRAWN BY MUSCIA	
REMOVE ALL BURRS AND BREAK SHARP EDGES TO RAZ.		DATE 2/18/93	
SURFACE FINISH TO BE IN ACCORDANCE WITH LATEST ASST. 944		CHECKED BY	
POLISHING & TOLERANCE TO BE IN ACCORDANCE WITH LATEST ASST. 944		DESIGNER MUSCIA	
DO NOT SCALE DRAWING		RESPONSIBLE ENGINEER	
		APPROVED/RELEASED	
		PROJECT MOR	
		MATERIAL SEE PARTS LIST	
		SCALE HALF	
		SHEET 1 of 1	
		SIZE C	
		DRAWING NUMBER 4105090702-940000-00	

SYN	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

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